Date: Monday, 4/23/2007 1:49:49 PM
User: Kim Johnston

# Process Sheet

| | | | |
|---|---|---|---|
| **Customer** | : CU-DAR001 Dart Helicopters Services | **Drawing Name** | : HELI UTILITY BASKET LH/RH 350/355 |
| **Job Number** | : 31988 | | |
| **Estimate Number** | : 10208 | | |
| **P.O. Number** | : N/A | **Part Number** | : D350607043 |
| **This Issue** | : 4/23/2007 **S.O. No.** : N/A | **Drawing Number** | : D350-607 REV F P7-9 |
| **Prsht Rev.** | : NC | **Project Number** | : N/A |
| **First Issue** | : N/A **Type** : LARGE FAB ASSY | **Drawing Revision** | : F |
| **Previous Run** | : 31799 | **Material** | : N/A |
| **Written By** | : | **Due Date** | : 5/15/2007 **Qty:** 1 **Um:** Each |
| **Checked & Approved By** | : 07.04.23 | | |
| **Comment** | : Est Rev:E as Per DSI9318 06-01-24 JLM | | |

**Additional Product**

Job Number:

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 1.0 | DC | DOCUMENT CONTROL |
| | **Comment:** DOCUMENT CONTROL<br>Photocopy bluefile & type labels per PPPD350-607-043 CHG003 | |
| 2.0 | 31988A | ~~BASKET LID ASSEMBLY~~ |
| | **Comment:** Sub-Component BASKET LID ASSEMBLY<br>D2989-041 B 31988 A | ml 07/05/15 |
| 3.0 | 31988B | BASKET LID ASSEMBLY |
| | **Comment:** Sub-Component BASKET LID ASSEMBLY<br>D2989-043 B 31988 B | ml 07/05/15 |
| 4.0 | 31988C | BASKET BASE ASSEMBLY (350) |
| | **Comment:** Sub-Component BASKET BASE ASSEMBLY (350)<br>D2221 B 31988C | ml 07/05/15 |
| 5.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
| | **Comment:** PACKAGING RESOURCE #1<br>Pick: Assemby Kit | |
| 6.0 | NAS1515H4 | Washer |
| | **Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)<br>Pick: Assemby Kit<br>Qty Part Number Description Batch<br>2 NAS1515H4 WASHER M101428 | 7/6/15 |



Form: mprocess

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

**Part No:** ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

**QA: N/C Closed:** _____ **Date:** _________

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**NOTE:** Date & initial all entries

Date: Monday, 4/23/2007 1:49:49 PM
User: Kim Johnston

# Process Sheet

**Customer:** CU-DAR001 Dart Helicopters Services **Drawing Name:** HELI UTILITY BASKET LH/RH 350/355

**Job Number:** 31988 **Part Number:** D350607043

Job Number:

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 7.0 | D2022101 | Spacer |

Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
5 D2022-101 Spacer B26664

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 8.0 | D2258200 | Weight Placard 200lb |

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
1 D2258-200 Label B31104

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 9.0 | D2332041 | Lid Prop Assembly 6.69" |

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
1 D2332-041 Prop Ass'y B30547

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 10.0 | D2530 | Handle Weldment |

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
1 D2530 Handle Weldment B30383

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 11.0 | D2535 | Spring |

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
2 D2535 Spring B28363

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 12.0 | D2537 | Bushing |

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
2 D2537 Bushing B31107

7/5/15 59



Form: rprocess

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

**Part No:** ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

**QA: N/C Closed:** _____ **Date:** _________

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**NOTE:** Date & initial all entries

Date: Monday, 4/23/2007 1:49:49 PM
User: Kim Johnston

# Process Sheet

**Customer:** CU-DAR001 Dart Helicopters Services **Drawing Name:** HELI UTILITY BASKET LH/RH 350/355

**Job Number:** 31988 **Part Number:** D350607043

Job Number:

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 13.0 | D27283 | Dart Logo label large |

**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit

| Qty | Part Number | Description | Batch |
|---|---|---|---|
| 2 | D2728-3 | Label | B22559 |

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 14.0 | D2931 | Bumper |

**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit

| Qty | Part Number | Description | Batch |
|---|---|---|---|
| 2 | D2931 | Bumper | B21139 |

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 15.0 | AN316A | Bolt |

**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit

| Qty | Part Number | Description | Batch |
|---|---|---|---|
| 2 | AN3-16A | Bolt | M101884 |

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 16.0 | AN413A | Bolt |

**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit

| Qty | Part Number | Description | Batch |
|---|---|---|---|
| 2 | AN4-13A | Bolt | M103947 |

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 17.0 | AN422A | Bolt |

**Comment:** Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)
Pick: Assemby Kit

| Qty | Part Number | Description | Batch |
|---|---|---|---|
| 7 | AN4-22A | Bolt | M100771 |

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 18.0 | AN517A | Bolt |

**Comment:** Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Assemby Kit

| Qty | Part Number | Description | Batch |
|---|---|---|---|
| 4 | AN5-17A | Bolt | M102140 |

7/5/15 SG

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

**Part No:** ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

**QA: N/C Closed:** _____ **Date:** ________

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**NOTE:** Date & initial all entries

# Process Sheet

**Customer:** CU-DAR001 Dart Helicopters Services **Drawing Name:** HELI UTILITY BASKET LH/RH 350/355

**Job Number:** 31988 **Part Number:** D350607043

Job Number:

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 19.0 | AN960JD8 | Washer |

**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
2 AN960JD8 Washer M103585

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 20.0 | AN960JD416 | Washer |

**Comment:** Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
14 AN960JD416 Washer M102929

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 21.0 | AN960JD416L | Washer |

**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
2 AN960JD416L Washer M103962

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 22.0 | AN960JD516 | Washer |

**Comment:** Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
4 AN960JD516 Washer M103641

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 23.0 | AN9704 | Washer |

**Comment:** Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
4 AN970-4 Washer M103344

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 24.0 | MS20600AD4W3 | Cherry Rivets |

**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
2 MS20600AD4W3 Rivet M101519

7/5/15 SD

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

**Part No:** ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

**QA: N/C Closed:** _____ **Date:** _________

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
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**NOTE:** Date & initial all entries

Date: Monday, 4/23/2007 1:49:49 PM
User: Kim Johnston

# Process Sheet

**Customer:** CU-DAR001 Dart Helicopters Services **Drawing Name:** HELI UTILITY BASKET LH/RH 350/355

**Job Number:** 31988 **Part Number:** D350607043

Job Number:

| **Seq. #:** | **Machine Or Operation:** | **Description :** |
|---|---|---|
| 25.0 | MS21042L3 | Nut |

**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch *
2 MS21042L3 Nut (or -3) M102217

| 26.0 | MS21042L4 | Nut |
|---|---|---|

**Comment:** Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
9 MS21042L4 Nut (or -4) M103914

| 27.0 | MS21042L5 | Nut |
|---|---|---|

**Comment:** Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
4 MS21042L5 Nut (or -5) M102536 7/5/15 SD

| 28.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|---|---|---|

**Comment:** SMALL & MEDIUM FAB RESOURCE 1
Assemble as per Dwg D350-607
Seal Support Gusset with Sikaflex -291
Batch: M 103497
Exp Date: 10/2007

ML 07/05/15 X1

| 29.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|---|---|---|

07-05-15 (1)

**Comment:** INSPECT WORK TO CURRENT STEP

| 30.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|---|---|---|

**Comment:** PACKAGING RESOURCE #1
Pick: Packing Kit

Dart Aerospace Ltd

| W/O: | WORK ORDER CHANGES | | | | | | |
|---|---|---|---|---|---|---|---|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: ________________ PAR #: ______ Fault Category: ________________ NCR: Yes No DQA: _____ Date: _________

QA: N/C Closed: _____ Date: _________

| NCR: | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**NOTE:** Date & initial all entries

Date: Monday, 4/23/2007 1:49:49 PM
User: Kim Johnston

# Process Sheet

**Customer:** CU-DAR001 Dart Helicopters Services
**Drawing Name:** HELI UTILITY BASKET LH/RH 350/355

**Job Number:** 31988
**Part Number:** D350607043

Job Number:

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 31.0 | D22301 | Mounting Lug |

**Comment:** Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
4 D2230-1 Lug B30992 ✓

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 32.0 | D22303 | Mounting Lug |

**Comment:** Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
4 D2230-3 Clamp B29806 ✓

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 33.0 | D23241 | Strut Assembly |

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
1 *D2324-1 Strut Ass'y B30139 ✓

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 34.0 | D2856400 | Abrasion Strip |

**Comment:** Qty.: 0.6000 f(s)/Unit Total : 0.6000 f(s)
Pick: Packing Kit
Qty Part Number Description Batch
4 D2856-400-720 Abrasion Strip B30822 ✓

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 35.0 | AN412A | Bolt |

**Comment:** Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
5 AN4-12A Bolt M108947 ✓

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 36.0 | AN413A | Bolt |

**Comment:** Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch_
8 AN4-13A Bolt M104156 ✓

07/05/15


Form: rprocess

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: ______ PAR #: ______ Fault Category: ______ NCR: Yes (No) DQA: [signature] Date: 07/05/15

QA: N/C Closed: ______ Date: ______

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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**NOTE:** Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

Date: Monday, 4/23/2007 1:49:49 PM
User: Kim Johnston

# Process Sheet

**Customer:** CU-DAR001 Dart Helicopters Services
**Drawing Name:** HELI UTILITY BASKET LH/RH 350/355

**Job Number:** 31988
**Part Number:** D350607043

Job Number:

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 37.0 | AN960JD416 | Washer |

**Comment:** Qty.: 26.0000 Each(s)/Unit Total : 26.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
26 AN960JD416 Washer M102929

| 38.0 | MS21042L4 | Nut |
|---|---|---|

**Comment:** Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
13 MS21042L4 Nut (or -4) M103914

07/05/15

| 39.0 | QC4 | INSPECT 100% KITS FOR COMPLETENESS |
|---|---|---|

07/05/15 (1)

**Comment:** INSPECT 100% KITS FOR COMPLETENESS

7/5/15 (1)

| 40.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|---|---|---|

**Comment:** PACKAGING RESOURCE #1
Identify and pack for shipping as per PPP D350-607-043
Location:__________ RIV: E 07/05/15

| 41.0 | QC21 | FINAL INSPECTION/W/O RELEASE |
|---|---|---|

**Comment:** FINAL INSPECTION/W/O RELEASE

(1) 07/05/15

Job Completion

07.05.15

Dart Aerospace Ltd

| W/O: | WORK ORDER CHANGES | | | | | | |
|---|---|---|---|---|---|---|---|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

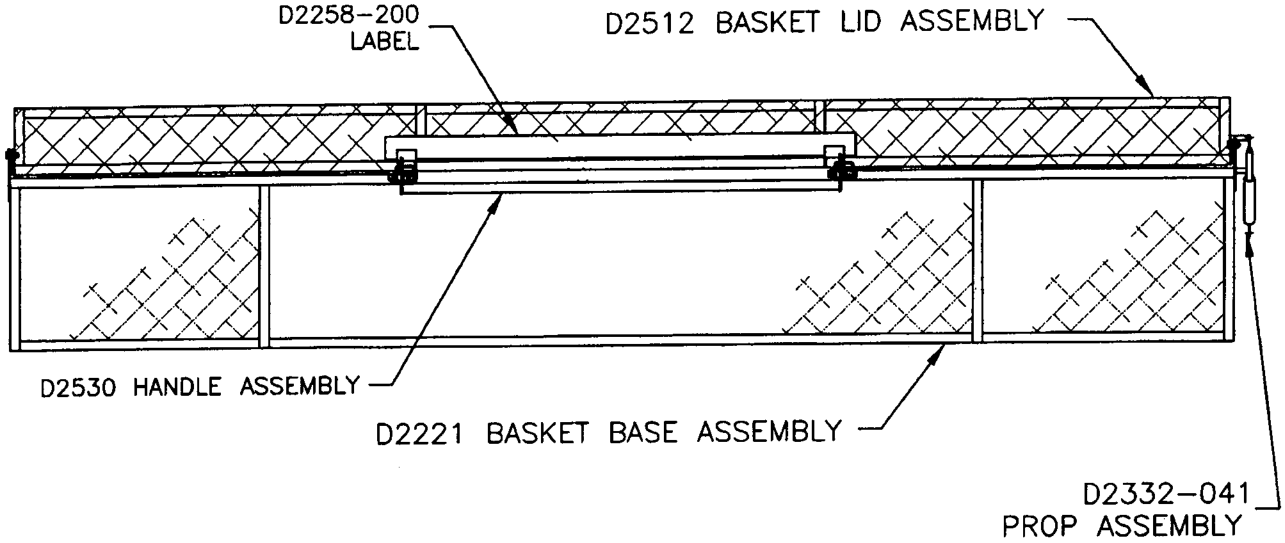
**Part No:** ________________ **PAR #:** ______ **Fault Category:** ________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

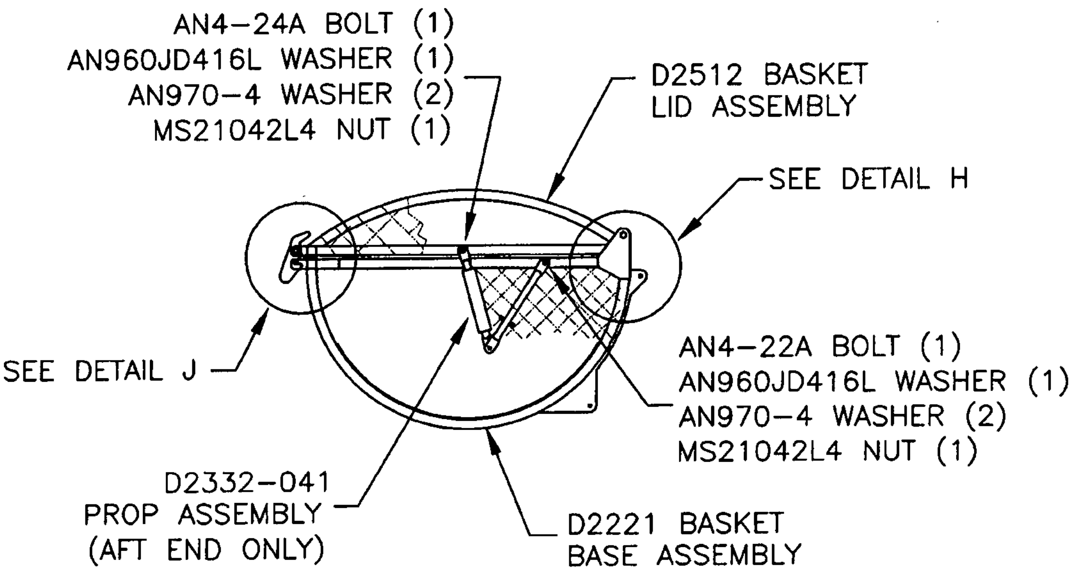
**QA: N/C Closed:** _____ **Date:** _________

| NCR: | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**NOTE:** Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD




PROP ARM DETAIL
(VIEW C-C)



***Figure 4 – Basket Replacement Parts***
*(D350-607-041 Heli-Utility-Basket™)*

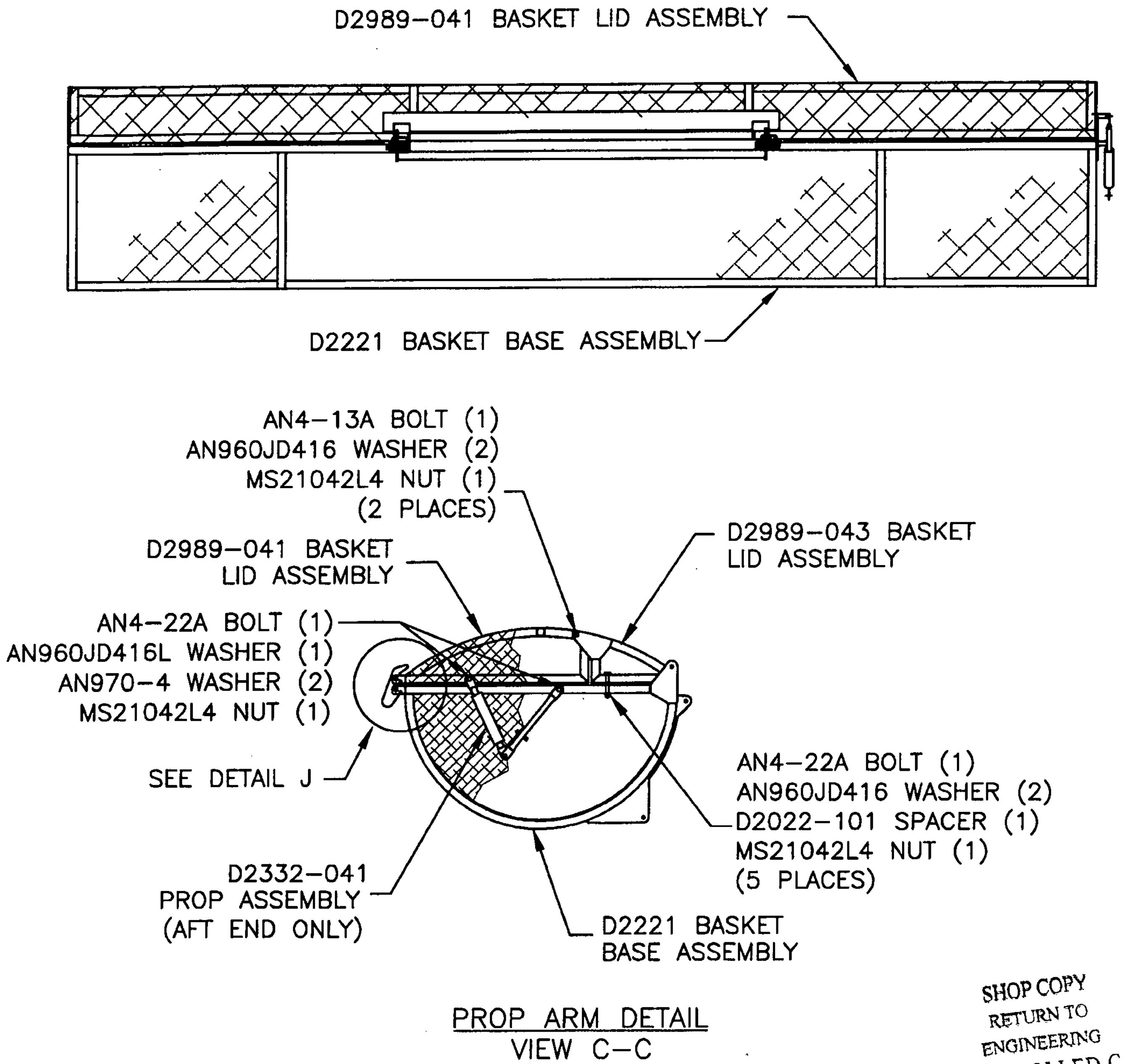
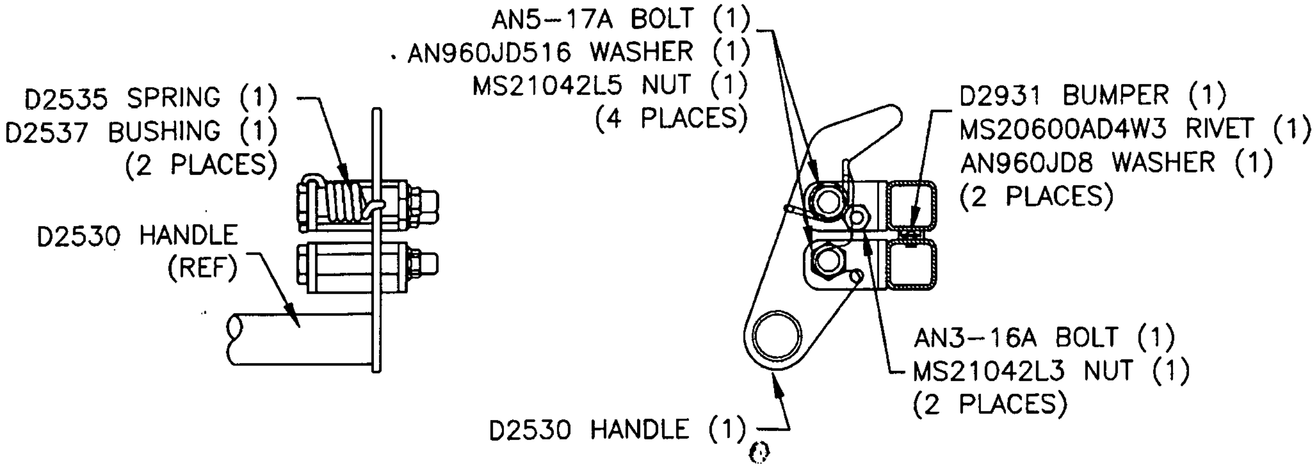




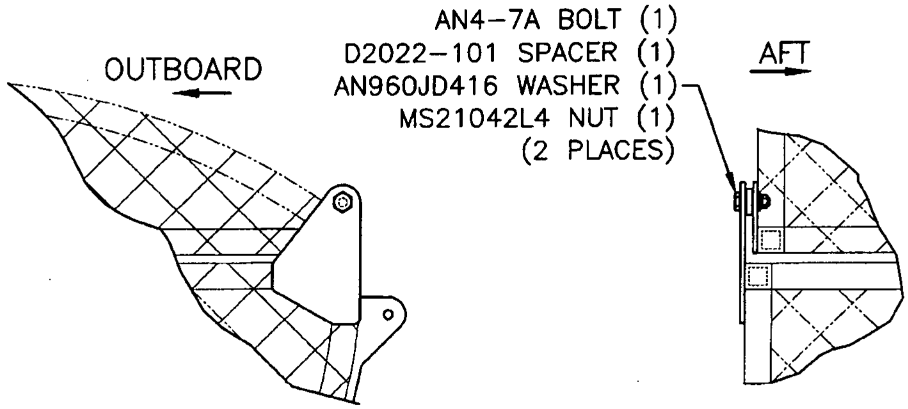

***Figure 5– Basket Replacement Parts***
*(D350-607-043 Heli-Utility-Basket™)*




SPRING DETAIL

LATCH DETAIL

<u>DETAIL J:</u>
HANDLE WELDMENT




<u>HINGE DETAIL</u>
END VIEW, LOOKING AFT
OTHER END OPPOSITE

<u>HINGE DETAIL</u>
SIDE VIEW, LOOKING OUTBOARD.
OTHER END OPPOSITE

<u>DETAIL H:</u>
HINGE



***Figure 6 – Basket Replacement Parts***

| DESIGN | DRAWN BY | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA | |
|---|---|---|---|
| CHECKED | APPROVED | DRAWING NO.<br>DSI 9318 | REV. A<br>SHEET 1 OF 1 |
| DATE<br>06.01.06 | | TITLE<br>WASHER ADDITION | SCALE<br>NTS |
| A | 06.01.06 | NEW ISSUE | |

DART

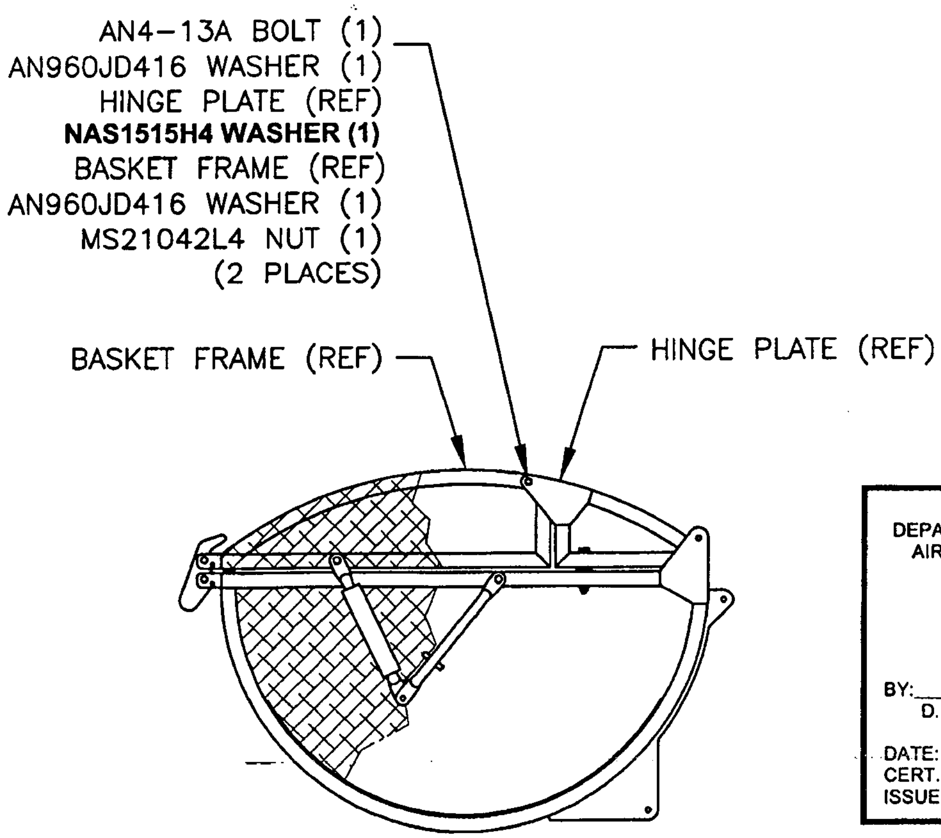
# DART SERVICE INSTRUCTION

**TO AMEND INSTALLATION INSTRUCTIONS D350-607 REV. F**

REF. CANADIAN STC: SH94-14 ISSUE 4
REF. FAA STC: SR00213NY

To reduce the possibility of damaging the finish, a **NAS1515H4** washer (2 places) has been added between the hinge plate and basket frame on the **D350-607-043/-047** *Heli-Utility-Basket*.

The corrected bolt stackup from Figure 5 of installation instructions D350-607 Rev. F is given below:




SHOP COPY RETURN TO ENGINEERING
UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE
WORK ORDER NO. 31988

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION BRANCH
DAO # 01-O-01

APPROVED

BY: D. SHEPHERD (DE # 02)

DATE: 06.01.06
CERT. NO.: SH94-14
ISSUE NO.: 4

Date: Monday, 4/23/2007 1:49:49 PM
User: Kim Johnston

# Process Sheet

| | | | |
|---|---|---|---|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : HELI UTILITY BASKET LH/RH 350/355 |
| Job Number | : 31988 | | |
| Estimate Number | : 10208 | | |
| P.O. Number | : | Part Number | : D350607043 |
| This Issue | : 4/23/2007 S.O. No. : | Drawing Number | : D350-607 REV F P7-9 |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : / / Type : LARGE FAB ASSY | Drawing Revision | : F |
| Previous Run | : 31799 | Material | : |
| Written By | : | Due Date | : 5/15/2007 Qty: 1 Um: Each |
| Checked & Approved By | : 07.04.23 | | |
| Comment | : Est Rev:E as Per DSI9318 06-01-24 JLM | | |

Additional Product

Job Number:

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 1.0 | DC | DOCUMENT CONTROL |

Comment: DOCUMENT CONTROL
Photocopy bluefile & type labels per PPPD350-607-043 CHG003

07.05.07

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 2.0 | 31988A | BASKET LID ASSEMBLY |

Comment: Sub-Component BASKET LID ASSEMBLY
D2989-041 B________

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 3.0 | 31988B | BASKET LID ASSEMBLY |

Comment: Sub-Component BASKET LID ASSEMBLY
D2989-043 B__________

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 4.0 | 31988C | BASKET BASE ASSEMBLY (350) |

REFERENCE ONLY

Comment: Sub-Component BASKET BASE ASSEMBLY (350)
D2221 B__________

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 5.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |

Comment: PACKAGING RESOURCE #1
Pick: Assemby Kit

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 6.0 | NAS1515H4 | Washer |

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit

| Qty | Part Number | Description | Batch |
|---|---|---|---|
| 2 | NAS1515H4 | WASHER | ____________ |

# Dart Aerospace Ltd.

Date: Monday, 4/23/2007 1:50:13 PM
User: Kim Johnston

## Process Sheet

| | | | |
|---|---|---|---|
| **Customer** | : CU-DAR001 Dart Helicopters Services | **Drawing Name** | : BASKET LID ASSEMBLY |
| **Job Number** | : 31988B | | |
| **Estimate Number** | : 10207 | | |
| **P.O. Number** | : N/A | **Part Number** | : D2989043 |
| **This Issue** | : 4/23/2007 **S.O. No.** : N/A | **Drawing Number** | : D2989 REV B |
| **Prsht Rev.** | : NC | **Project Number** | : N/A |
| **First Issue** | : N/A **Type** : LARGE FAB ASSY | **Drawing Revision** | : B |
| **Previous Run** | : 31799B | **Material** | : N/A |
| **Written By** | : | **Due Date** | : 5/15/2007 **Qty:** 1 **Um:** Each |
| **Checked & Approved By** | : [signature] 07.04.23 | | |
| **Comment** | : Est Rev:I Removed D2989-041 05-11-03 JLM | | |

**Additional Product**

Job Number:

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 1.0 | D31821 | Hinge |

✓ Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:
Qty Part number Description Batch
2 D3182-1 Hinge B31342

[signature] 07.05.11

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 2.0 | D34423 | Shim |

✓ Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:
Qty Part number Description Batch
2 D3442-3 Shim B26740

[signature] 07.05.11

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 3.0 | M304EX07516F | Expanded Metal Flat Stai |

✓ Comment: Qty.: 8.0000 sf(s)/Unit Total : 8.0000 sf(s)
Pick:
Qty Part number Description Batch
8sf M304EX0.75-16F Expanded Metal M103840

[signature] 07.05.11

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 4.0 | M304TS0750W065 | 304 SQ Tube.75x.75x.065W |

✓ Comment: Qty.: 17.6400 f(s)/Unit Total : 17.6400 f(s)
3/4" x 3/4" x 0.063" wall 304/316 SStubing.
Batch: M103701

[signature] 07.05.11

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

**Part No:** ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes (No) **DQA:** [illegible] **Date:** 07/05/15

**QA: N/C Closed:** _____ **Date:** _________

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| | | | Corrective Action Section B | | | | | |
| DATE | STEP | Description of NC Section A | Initial Chief Eng | Action Description Chief Eng | Sign & Date | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**NOTE:** Date & initial all entries

Date: Monday, 4/23/2007 1:50:13 PM
User: Kim Johnston

# Process Sheet

**Customer:** CU-DAR001 Dart Helicopters Services **Drawing Name:** BASKET LID ASSEMBLY

**Job Number:** 31988B **Part Number:** D2989043

Job Number:

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 5.0 | LARGE FAB 1 | LARGE FABRICATION RESOURCE 1 |

**Comment:** LARGE FABRICATION RESOURCE 1

1-Cut (4) D2236-1 From D3166-3 As Per Dwg D2989
Note:D2989-3/-4 On -041 Bom

2-Drill holes in tubing as D2989-043 per Dwg D2989

3-Deburr and remove all markings on material

4-Weld as per Dwg D2989 and D2989-043 Assembly using Welding Table and corner Jig. Deburr as required
Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid

CP 07.05.11

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 6.0 | QC9 | VISUAL WELDING INSPECTION |

**Comment:** VISUAL WELDING INSPECTION

07/05/14

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 7.0 | QC6 | DIMENSIONAL CHECK |

**Comment:** DIMENSIONAL CHECK

07/05/14

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 8.0 | POWDER COATING | POWDER COATING |

M103706

**Comment:** POWDER COATING

1-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

07-05-14 ①

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 9.0 | QC3 | INSPECT POWDER COAT/CHEMICAL CONVERSION |

**Comment:** Inspect Powder Coat

ml 07/05/15

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 10.0 | QC21 | FINAL INSPECTION/W/O RELEASE |

①

**Comment:** FINAL INSPECTION/W/O RELEASE

07/05/15

Job Completion

07.05.15

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

**Part No:** ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

**QA: N/C Closed:** _____ **Date:** _________

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**NOTE:** Date & initial all entries

DART

| DESIGN DS | DRAWN BY PH | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |
|---|---|---|
| CHECKED | APPROVED | DRAWING NO. D2989 REV. B SHEET 1 OF 3 |
| DATE 05.06.07 | | TITLE BASKET LID ASSEMBLY SCALE NTS |

| | | |
|---|---|---|
| A | 00.10.27 | NEW ISSUE |
| B | 05.06.07 | ADD SHIM UNDER HINGES,UPDATE LID DIMENSIONS |

RELEASED 05.08.19

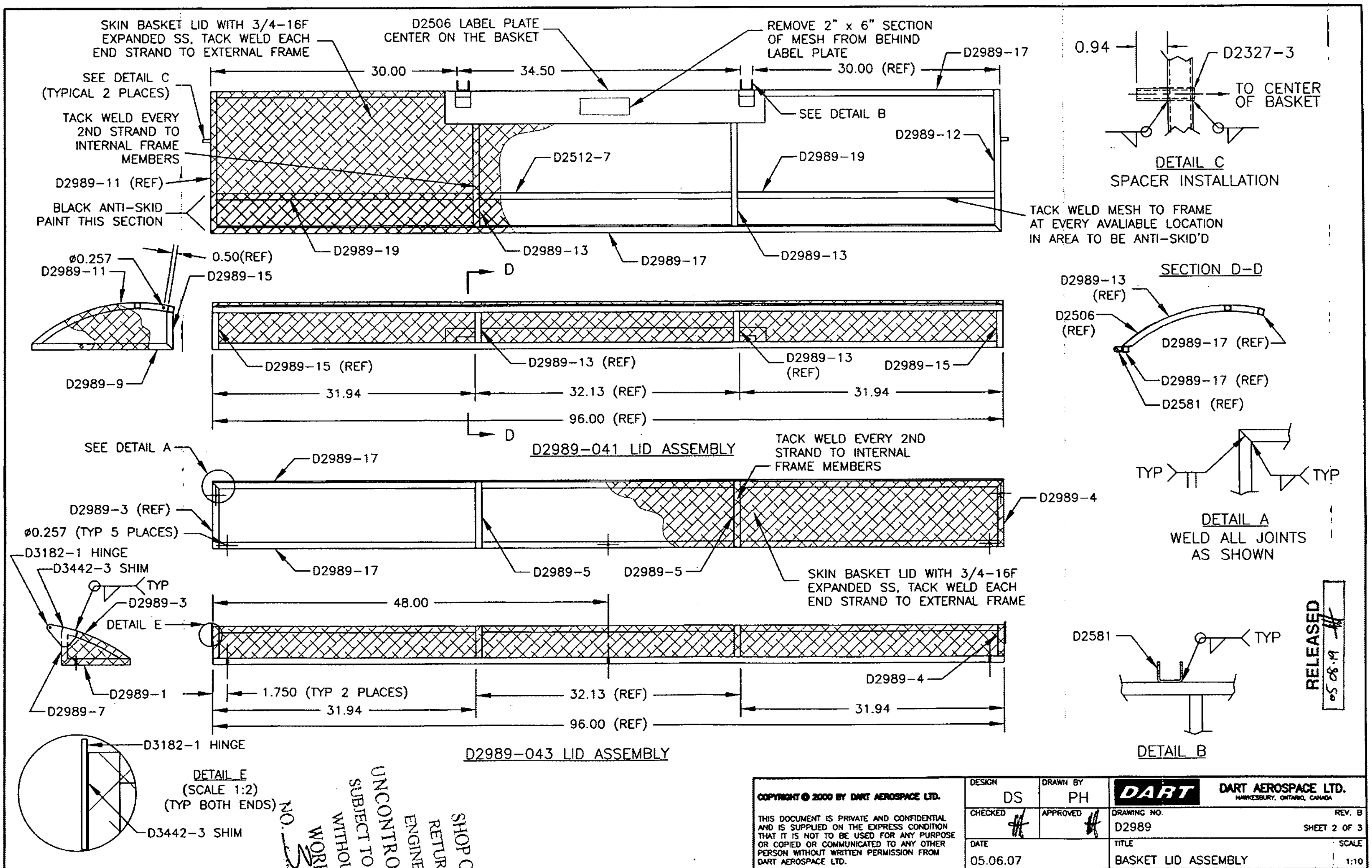
**PARTS LIST:**

| Qty -041 | Qty -043 | Part Number | Description |
|---|---|---|---|
| **X** | | **D2989-041** | **BASKET LID ASSEMBLY (OUTSIDE)** |
| | **X** | **D2989-043** | **BASKET LID ASSEMBLY (INSIDE)** |
| | | | |
| | 1 | D2989-1 | STRUT |
| | 1 | D2989-2 | STRUT |
| | 1 | D2989-3 | STRUT |
| | 1 | D2989-4 | STRUT |
| | 2 | D2989-5 | STRUT |
| | 2 | D2989-7 | STRUT |
| 1 | | D2989-9 | STRUT |
| 1 | | D2989-10 | STRUT |
| 1 | | D2989-11 | STRUT |
| 1 | | D2989-12 | STRUT |
| 2 | | D2989-13 | STRUT |
| 2 | | D2989-15 | STRUT |
| | | | |
| 2 | | D2327-3 | SPACER BUSHING |
| 1 | | D2506 | LABEL PLATE |
| 2 | 2 | D2989-17 | STRUT (96.00" LONG) |
| 2 | | D2989-19 | STRUT (31.19" LONG) |
| 1 | | D2512-7 | STRUT |
| 2 | | D2581 | MOUNTING BRACKET |
| | 2 | D3182-1 | HINGE |
| | 2 | D3442-3 | SHIM |



**NOTES:**

1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.060 WALL SQUARE TUBING
   D2989-3/4/5/11/12/13 CAN BE MADE FROM D2236
2) MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F)
3) WELD PER DART QSI 004
4) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.
   BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4. SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID.
5) ALL DIMENSIONS ARE IN INCHES
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED


SKIN BASKET LID WITH 3/4-16F EXPANDED SS, TACK WELD EACH END STRAND TO EXTERNAL FRAME
D2506 LABEL PLATE CENTER ON THE BASKET
REMOVE 2" x 6" SECTION OF MESH FROM BEHIND LABEL PLATE
D2989-17
SEE DETAIL C (TYPICAL 2 PLACES)
30.00
34.50
30.00 (REF)
TACK WELD EVERY 2ND STRAND TO INTERNAL FRAME MEMBERS
SEE DETAIL B
D2989-12
D2512-7
D2989-19
D2989-11 (REF)
BLACK ANTI-SKID PAINT THIS SECTION
TACK WELD MESH TO FRAME AT EVERY AVALIABLE LOCATION IN AREA TO BE ANTI-SKID'D
D2989-19
D2989-13
D2989-17
D2989-13
ø0.257
D2989-11
0.50(REF)
D2989-15
D2989-9
D
D2989-15 (REF)
D2989-13 (REF)
D2989-13 (REF)
D2989-15
31.94
32.13 (REF)
31.94
96.00 (REF)
D
D2989-041 LID ASSEMBLY
0.94
D2327-3
TO CENTER OF BASKET
DETAIL C
SPACER INSTALLATION
SECTION D-D
D2989-13 (REF)
D2506 (REF)
D2989-17 (REF)
D2989-17 (REF)
D2581 (REF)
SEE DETAIL A
D2989-17
TACK WELD EVERY 2ND STRAND TO INTERNAL FRAME MEMBERS
D2989-4
D2989-3 (REF)
ø0.257 (TYP 5 PLACES)
D3182-1 HINGE
D3442-3 SHIM
TYP
D2989-3
DETAIL E
D2989-17
D2989-5
D2989-5
SKIN BASKET LID WITH 3/4-16F EXPANDED SS, TACK WELD EACH END STRAND TO EXTERNAL FRAME
48.00
D2989-4
D2989-1
D2989-7
1.750 (TYP 2 PLACES)
32.13 (REF)
31.94
31.94
96.00 (REF)
D2989-043 LID ASSEMBLY
TYP
TYP
DETAIL A
WELD ALL JOINTS AS SHOWN
D2581
TYP
DETAIL B
RELEASED
05.08.19
D3182-1 HINGE
DETAIL E
(SCALE 1:2)
(TYP BOTH ENDS)
D3442-3 SHIM
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO.
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DATE 05.06.07
DART
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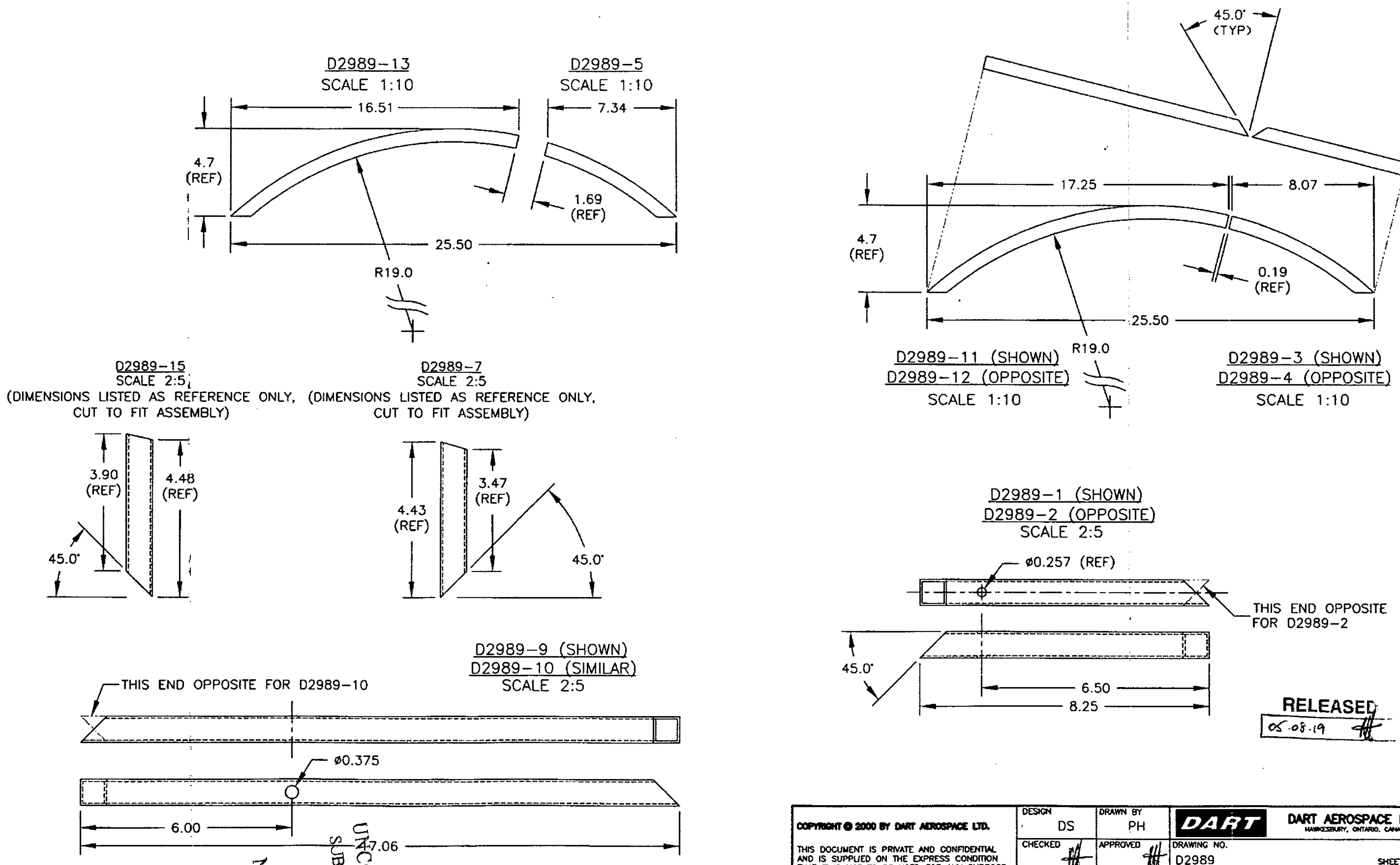
HAWKESBURY, ONTARIO, CANADA
DRAWING NO. D2989
REV. B
SHEET 2 OF 3
TITLE BASKET LID ASSEMBLY
SCALE 1:10






| DESIGN | DRAWN BY |
|---|---|
| DS | PH |
| CHECKED | APPROVED |
| DATE 05.06.07 | |

DART AEROSPACE LTD.
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D2989 — REV. B — SHEET 3 OF 3

TITLE: BASKET LID ASSEMBLY — SCALE 1:10

Date: Monday, 4/23/2007 1:50:04 PM
User: Kim Johnston

# Process Sheet

| | | | |
|---|---|---|---|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : BASKET LID ASSEMBLY |
| Job Number | : 31988A | | |
| Estimate Number | : 10206 | | |
| P.O. Number | : N/A | Part Number | : D2989041 |
| This Issue | : 4/23/2007 S.O. No. : N/A | Drawing Number | : D2989 REV B |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : N/A Type : LARGE FAB ASSY | Drawing Revision | : B |
| Previous Run | : 31799A | Material | : N/A |
| Written By | : | Due Date | : 5/15/2007 Qty: 1 Um: Each |
| Checked & Approved By | : [signature] 07.04.23 | | |
| Comment | : Est Rev:I Removed D2989-043 05-11-03 JLM | | |

**Additional Product**

Job Number:

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 1.0 | D31663 | Basket Hoop |

✓ Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:
Qty.(1) D3166-3 Batch: B31118
[signature] 07.05.11

| 2.0 | D2581 | Mounting Bracket |
|---|---|---|

✓ Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

| Qty | Part number | Description | Batch |
|---|---|---|---|
| 2 | D2581 | Mounting Brackets | B30552 |

[signature] 07.05.11

| 3.0 | D23273 | Spacer Bushing |
|---|---|---|

✓ Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

| Qty | Part number | Description | Batch |
|---|---|---|---|
| 2 | D2327-3 | Bushing | B28597 |

[signature] 07.05.11

| 4.0 | D2506 | Placard |
|---|---|---|

✓ Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

| Qty | Part number | Description | Batch |
|---|---|---|---|
| 1 | D2506 | Label Plate | B30548 |

[signature] 07.05.11

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: ____________________ PAR #: _______ Fault Category: _________________ NCR: Yes No DQA: _____ Date: _________

QA: N/C Closed: _____ Date: _________

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**NOTE:** Date & initial all entries

Date: Monday, 4/23/2007 1:50:04 PM
User: Kim Johnston

# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services  Drawing Name: BASKET LID ASSEMBLY

Job Number: 31988A  Part Number: D2989041

Job Number:

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 5.0 | M304EX07516F | Expanded Metal Flat Stai |

Comment: Qty.: 15.0000 sf(s)/Unit Total : 15.0000 sf(s)
Pick:
Qty Part number Description Batch
15sf M304EX0.75-16F Expanded Metal M103840 Cpl 07·05·11

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 6.0 | M304TS0750W065 | 304 SQ Tube.75x.75x.065W |

Comment: Qty.: 31.7709 f(s)/Unit Total : 31.7709 f(s)
3/4" x 3/4" x 0.063" wall 304/316 SStubing.
Batch: M103701 Cpl 07·05·11

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 7.0 | LARGE FAB 1 | LARGE FABRICATION RESOURCE 1 |

Comment: LARGE FABRICATION RESOURCE 1

1-Cut (4) D2236-1 From D3166-3 As Per Dwg D2989

2-Drill holes in tubing as D2989-041 per Dwg D2989

3-Deburr and remove all markings on material

4-Weld as per Dwg D2989 and D2989-041 Assembly using Welding Table and corner Jig. Deburr as required
Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid

5-Drill Ø0.257" hole as D2989-041 per Dwg D2989Identify as D2989-041 Cpl 07·06·11

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 8.0 | QC9 | VISUAL WELDING INSPECTION |

Comment: VISUAL WELDING INSPECTION 07/05/14

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 9.0 | QC5 | INSPECT WORK TO CURRENT STEP |

Comment: INSPECT WORK TO CURRENT STEP 07/05/14

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 10.0 | POWDER COATING | POWDER COATING |

M103706

Comment: POWDER COATING

1-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

07-05-14 (1)



Form: process

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes $\boxed{\text{No}}$ DQA: [signature] Date: 07/05/15

QA: N/C Closed: _____ Date: ________

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**NOTE:** Date & initial all entries

Date: Monday, 4/23/2007 1:50:04 PM
User: Kim Johnston

# Process Sheet

**Customer:** CU-DAR001 Dart Helicopters Services **Drawing Name:** BASKET LID ASSEMBLY

**Job Number:** 31988A **Part Number:** D2989041

Job Number:

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| | 2-Wing walk D2989-041 as per Dwg D2989 and QSI 005 4.4<br>Spray Paint Black: M107153<br>Wing Walk: M103707 | 07/05/15 |
| 11.0 | QC3 | INSPECT POWDER COAT/CHEMICAL CONVERSION |
| | **Comment:** Inspect Powder Coat and Wing Walk | 07/05/15 |
| 12.0 | QC21 | FINAL INSPECTION/W/O RELEASE |
| | **Comment:** FINAL INSPECTION/W/O RELEASE | 07/05/15 |

Job Completion

07.05.15



Form: rprocess

Dart Aerospace Ltd

| W/O: | WORK ORDER CHANGES | | | | | | |
|---|---|---|---|---|---|---|---|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

**Part No:** ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

**QA: N/C Closed:** _____ **Date:** _________

| NCR: | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**NOTE:** Date & initial all entries

DART

| DESIGN | DRAWN BY | DART AEROSPACE LTD |
|---|---|---|
| DS | PH | HAWKESBURY, ONTARIO, CANADA |
| CHECKED | APPROVED | DRAWING NO. D2989 REV. B SHEET 1 OF 3 |
| DATE 05.06.07 | | TITLE BASKET LID ASSEMBLY SCALE NTS |

| | | |
|---|---|---|
| A | 00.10.27 | NEW ISSUE |
| B | 05.06.07 | ADD SHIM UNDER HINGES,UPDATE LID DIMENSIONS |

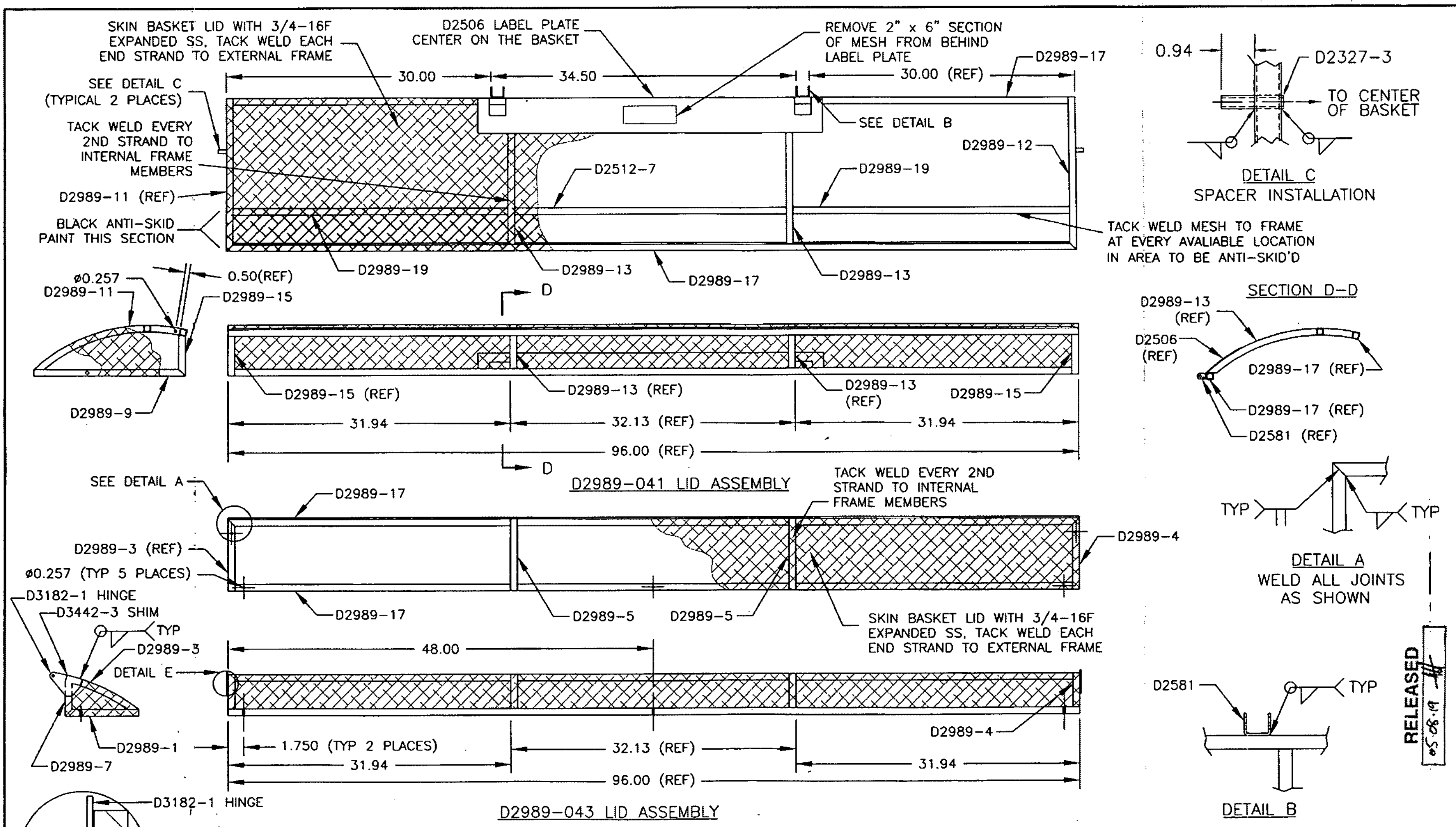
**RELEASED**
05.08.19

**PARTS LIST:**

| Qty -041 | Qty -043 | Part Number | Description |
|---|---|---|---|
| X | | **D2989-041** | **BASKET LID ASSEMBLY (OUTSIDE)** |
| | X | **D2989-043** | **BASKET LID ASSEMBLY (INSIDE)** |
| | | | |
| | 1 | D2989-1 | STRUT |
| | 1 | D2989-2 | STRUT |
| | 1 | D2989-3 | STRUT |
| | 1 | D2989-4 | STRUT |
| | 2 | D2989-5 | STRUT |
| | 2 | D2989-7 | STRUT |
| 1 | | D2989-9 | STRUT |
| 1 | | D2989-10 | STRUT |
| 1 | | D2989-11 | STRUT |
| 1 | | D2989-12 | STRUT |
| 2 | | D2989-13 | STRUT |
| 2 | | D2989-15 | STRUT |
| | | | |
| 2 | | D2327-3 | SPACER BUSHING |
| 1 | | D2506 | LABEL PLATE |
| 2 | 2 | D2989-17 | STRUT (96.00" LONG) |
| 2 | | D2989-19 | STRUT (31.19" LONG) |
| 1 | | D2512-7 | STRUT |
| 2 | | D2581 | MOUNTING BRACKET |
| | 2 | D3182-1 | HINGE |
| | 2 | D3442-3 | SHIM |



**NOTES:**
1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.060 WALL SQUARE TUBING
D2989-3/4/5/11/12/13 CAN BE MADE FROM D2236
2) MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F)
3) WELD PER DART QSI 004
4) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4. SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID.
5) ALL DIMENSIONS ARE IN INCHES
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED




RELEASED 05.08.19

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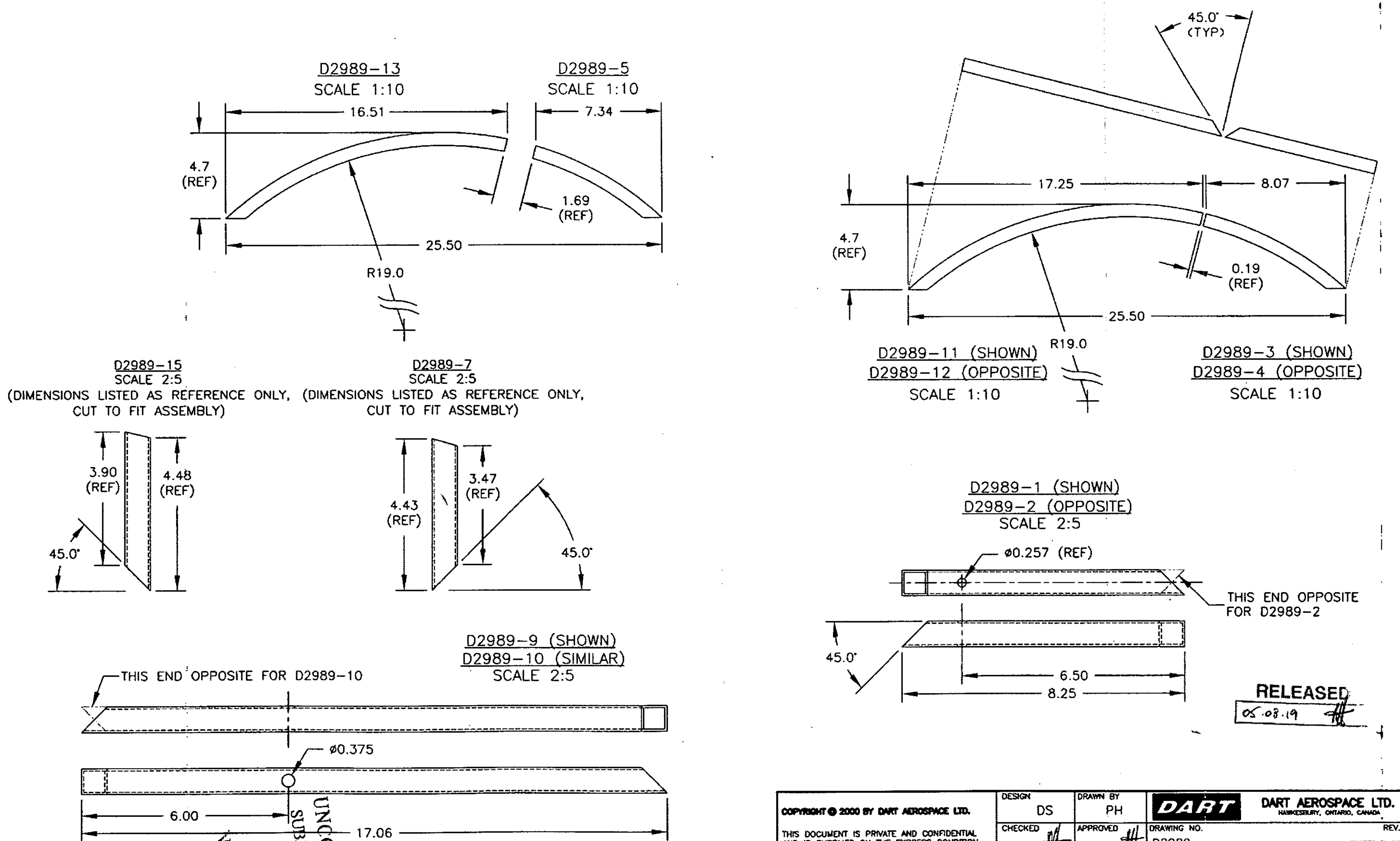
| | DATE: 05.06.07 | | TITLE: BASKET LID ASSEMBLY | SCALE 1:10 |



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|---|---|---|
| DS | PH | DRAWING NO. D2989 — REV. B — SHEET 3 OF 3 |
| CHECKED | APPROVED | |
| DATE 05.06.07 | | TITLE BASKET LID ASSEMBLY — SCALE 1:10 |

**Dart Aerospace Ltd.**

Date: Monday, 4/23/2007 1:50:31 PM
User: Kim Johnston

# Process Sheet

| | | | |
|---|---|---|---|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : BASKET BASE ASSEMBLY (350) |
| Job Number | : 31988C | | |
| Estimate Number | : 10189 | | |
| P.O. Number | : N/A | Part Number | : D2221 |
| This Issue | : 4/23/2007 S.O. No. : N/A | Drawing Number | : D2221/D2235 |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : N/A Type : LARGE FAB ASSY | Drawing Revision | : F/B1 |
| Previous Run | : 31799C | Material | : N/A |
| Written By | : | Due Date | : 5/15/2007 Qty: 1 Um: Each |
| Checked & Approved By | : 07.04.23 | | |
| Comment | : Est Rev: 05.09.02 Added D3442-1 KJ/JLM | | |

**Additional Product**

Job Number:

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 1.0 | D31661 | Basket Hoop |

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|---|---|---|---|
| 4 | D3166-1 | RIB | B31491 → 3 B31425 → 1 ✓ |

CpC 07-05-11

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 2.0 | D22323 | Basket Hinge |

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|---|---|---|---|
| 2 | D2232-3 | Hinge bracket | B30873 |

✓ CpC 07·05·11

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 3.0 | D2325 | Support Gusset (350 Bask |

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|---|---|---|---|
| 4 | D2325 | Support Gusset | B30546 |

✓ CpC 07·05·11

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 4.0 | D23273 | Spacer Bushing |

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|---|---|---|---|
| 2 | D2327-3 | Bushing | 328597 |

✓ CpC 07·05·11

Dart Aerospace Ltd

| W/O: | WORK ORDER CHANGES | | | | | | |
|---|---|---|---|---|---|---|---|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

**Part No:** ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

**QA: N/C Closed:** _____ **Date:** _________

| NCR: | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**NOTE:** Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

Date: Monday, 4/23/2007 1:50:32 PM
User: Kim Johnston

# Process Sheet

**Customer:** CU-DAR001 Dart Helicopters Services
**Drawing Name:** BASKET BASE ASSEMBLY (350)

**Job Number:** 31988C
**Part Number:** D2221

Job Number:

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 5.0 | D2581 | Mounting Bracket |

**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

| Qty | Part Number | Description | Batch |
|---|---|---|---|
| 2 | D2581 | Mounting Bracket | B30552 |

✓ CPC 07.05.11

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 6.0 | D34421 | Shim |

**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

| Qty | Part Number | Description | Batch |
|---|---|---|---|
| 2 | D3442-1 | Shim | B30564 |

✓ CPC 07.05.11

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 7.0 | M304EX07516F | Expanded Metal Flat Stai |

**Comment:** Qty.: 41.6745 sf(s)/Unit Total : 41.6745 sf(s)
Pick:

| Qty | Part Number | Description | Batch |
|---|---|---|---|
| 39.69 sf | M304EX0.75-16F | Expanded Metal | M103840 |

* CPC 07.05.11

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 8.0 | M304TS0750W065 | 304 SQ Tube.75x.75x.065W |

**Comment:** Qty.: 29.4000 f(s)/Unit Total : 29.4000 f(s)
Pick:
28' 3/4" x 3/4" x 0.063 wall 304/316 SStubing
Batch: M103701

✓ CPC 07.05.11

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 9.0 | LARGE FAB 1 | LARGE FABRICATION RESOURCE 1 |

**Comment:** LARGE FABRICATION RESOURCE 1

1-Cut D2235-1 Rib from D3166-1 Rib As Per Dwg D2235

2-Drill hole in D2221-3 as per Dwg D2221

3-Deburr

4-Remove all markings on material before welding

5-Weld as per Dwg D2221 using Welding Table and corner JigDeburr as required

CPC 07.05.11

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

**Part No:** ______ **PAR #:** ______ **Fault Category:** ______ **NCR:** Yes No **DQA:** [signature] **Date:** 07/05/15

**QA: N/C Closed:** _____ **Date:** _________

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**NOTE:** Date & initial all entries

Date: Monday, 4/23/2007 1:50:32 PM
User: Kim Johnston

# Process Sheet

**Customer:** CU-DAR001 Dart Helicopters Services **Drawing Name:** BASKET BASE ASSEMBLY (350)

**Job Number:** 31988C **Part Number:** D2221

Job Number:

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 10.0 | QC9 | VISUAL WELDING INSPECTION |
| | **Comment:** VISUAL WELDING INSPECTION | 07/05/14 |
| 11.0 | QC6 | DIMENSIONAL CHECK |
| | **Comment:** DIMENSIONAL CHECK | 07/05/14 |
| 12.0 | POWDER COATING | POWDER COATING M103706 |
| | **Comment:** POWDER COATING<br>Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 | 07.05.14 (1) |
| 13.0 | QC3 | INSPECT POWDER COAT/CHEMICAL CONVERSION |
| | **Comment:** INSPECT POWDER COAT/CHEMICAL CONVERSION | ml 07/05/15 |
| 14.0 | QC21 | FINAL INSPECTION/W/O RELEASE (1) |
| | **Comment:** FINAL INSPECTION/W/O RELEASE | 07/05/15 |

Job Completion 07.05.15

 Form: mprocess

Dart Aerospace Ltd

| W/O: | WORK ORDER CHANGES | | | | | | |
|---|---|---|---|---|---|---|---|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

**Part No:** ____________ **PAR #:** _______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** _________

**QA: N/C Closed:** _____ **Date:** _________

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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| | | | | | | | | |

**NOTE:** Date & initial all entries

| DESIGN BW | DRAWN BY PH | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |
|---|---|---|
| CHECKED | APPROVED | DRAWING NO. D2221 — REV. F — SHEET 1 OF 3 |
| DATE 05.06.07 | | TITLE BASKET BASE ASSEMBLY (350) — SCALE NTS |

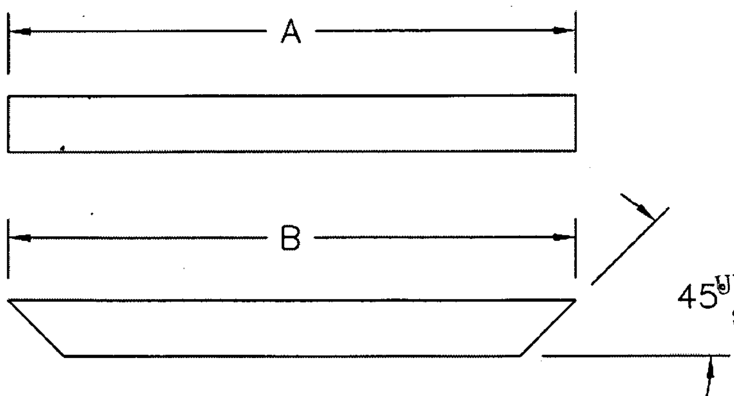
DART

RELEASED 05.08.19

| REV | DATE | DESCRIPTION |
|---|---|---|
| C | 95.11.21 | SEPARATE BASKET AND LID |
| D | 96.06.21 | CHANGE LATCH |
| E | 01.04.19 | CHANGE HINGE |
| F | 05.06.07 | ADD SHIM UNDER HINGES, ADD HOLES FOR SPLIT LID BASKETS |

PARTS LIST FOR D2221 BASKET BASE ASSEMBLY

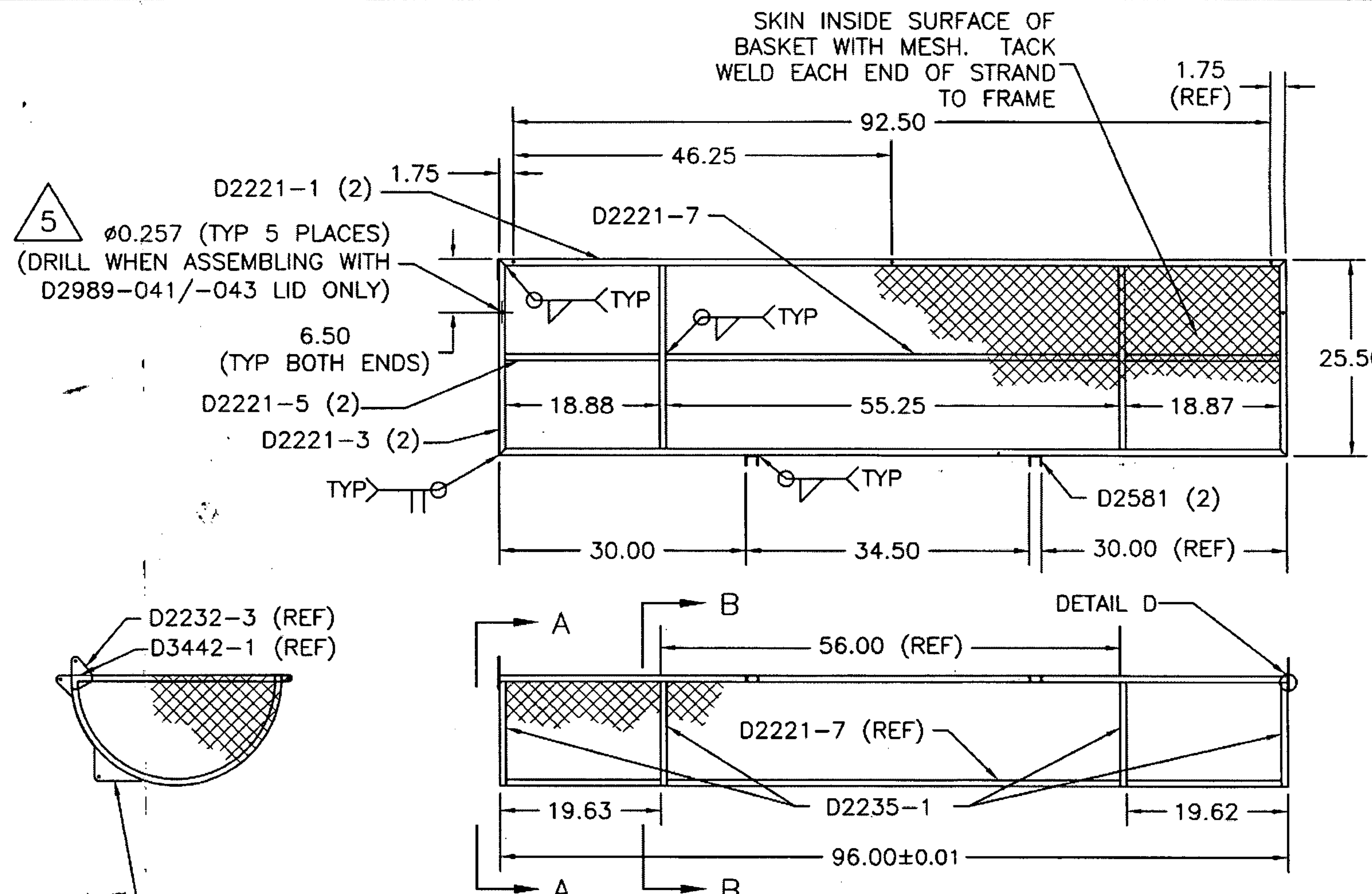
| PART NO | QUANTITY | LENGTH A | LENGTH B | DESCRIPTION |
|---|---|---|---|---|
| D2221-1 | 2 | —— | 96.00 | RIB |
| D2221-3 | 2 | —— | 25.50 | RIB |
| D2221-5 | 2 | 18.88 | —— | RIB |
| D2221-7 | 1 | 55.25 | —— | RIB |
| D2232-3 | 2 | N/A | N/A | HINGE PLATE |
| D2235-1 | 4 | N/A | N/A | RIB |
| D2325 | 4 | N/A | N/A | SUPPORT GUSSET |
| D2327-3 | 2 | N/A | N/A | BUSHING |
| D2581 | 2 | N/A | N/A | MTG BRKT |
| D3442-1 | 2 | N/A | N/A | SHIM |

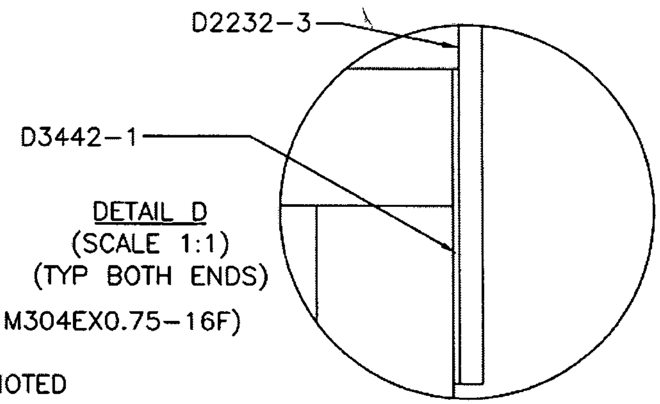





D2221-1/-3/-5/-7

1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING (REF. DART SPEC M304TS0.750W.060)
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) DRILL ⌀0.257 HOLES ONLY WHEN ASSEMBLING D2221 BASE WITH D2989-041/-043 BASKET LID




DETAIL D
(SCALE 1:1)
(TYP BOTH ENDS)



D2221 BASKET BASE ASSEMBLY

1) MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F)
2) WELD PER DART QSI 004
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3



DART

| | |
|---|---|
| DESIGN | BW |
| DRAWN BY | PH |
| CHECKED | |
| APPROVED | |
| DATE | 05.06.07 |
| DRAWING NO. | D2221 |
| TITLE | BASKET BASE ASSEMBLY (350) |
| REV. | F |
| SHEET | 2 OF 3 |
| SCALE | 1:20 |

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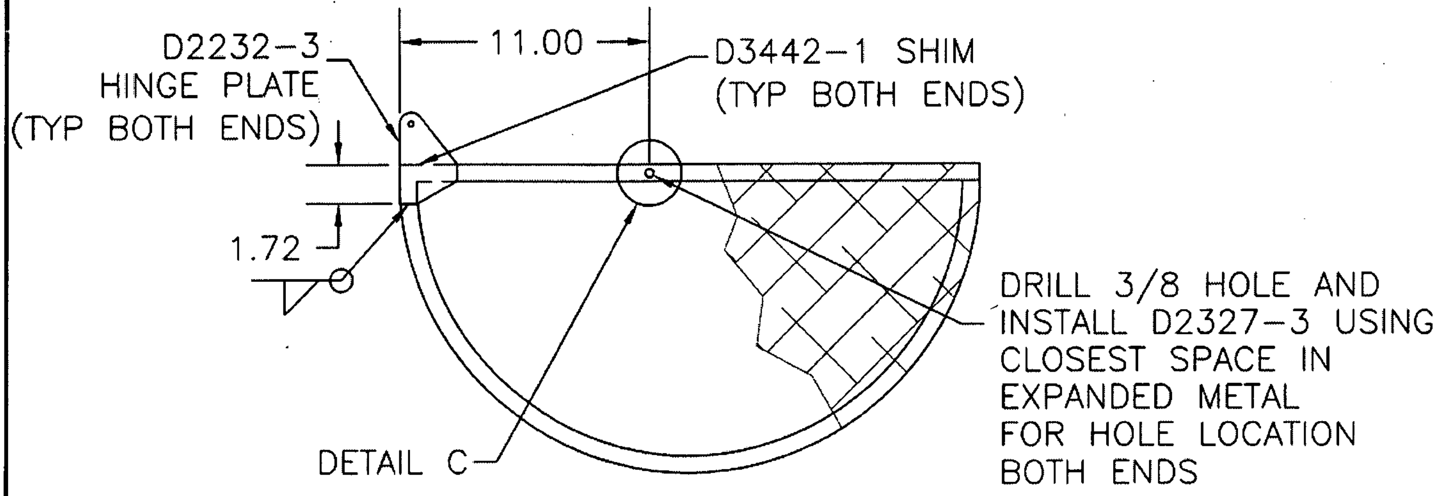
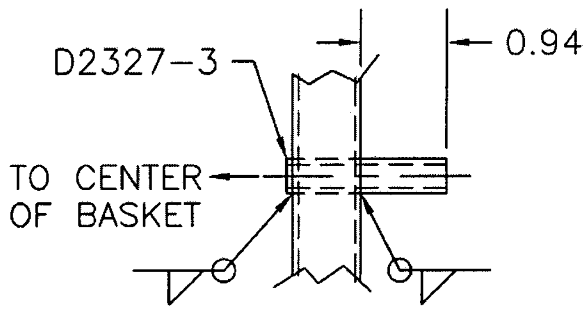
HAWKESBURY, ONTARIO, CANADA

DART

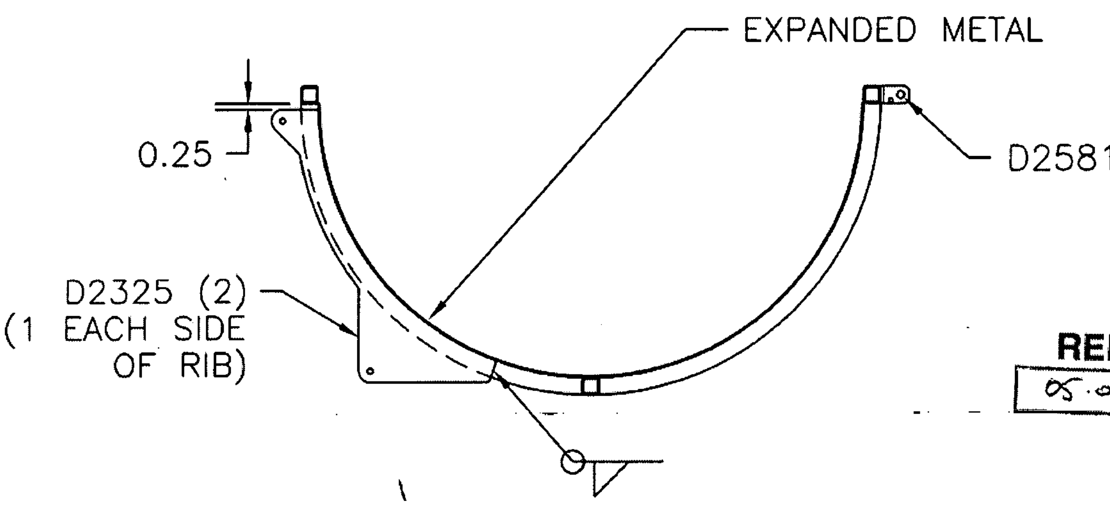
| DESIGN | DRAWN BY | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA | |
|---|---|---|---|
| BW | PH | | |
| CHECKED | APPROVED | DRAWING NO.<br>D2221 | REV. F<br>SHEET 3 OF 3 |
| DATE<br>05.06.07 | | TITLE<br>BASKET BASE ASSEMBLY (350) | SCALE<br>1:8 |




SECTION A-A SAME BOTH END RIBS




DETAIL C



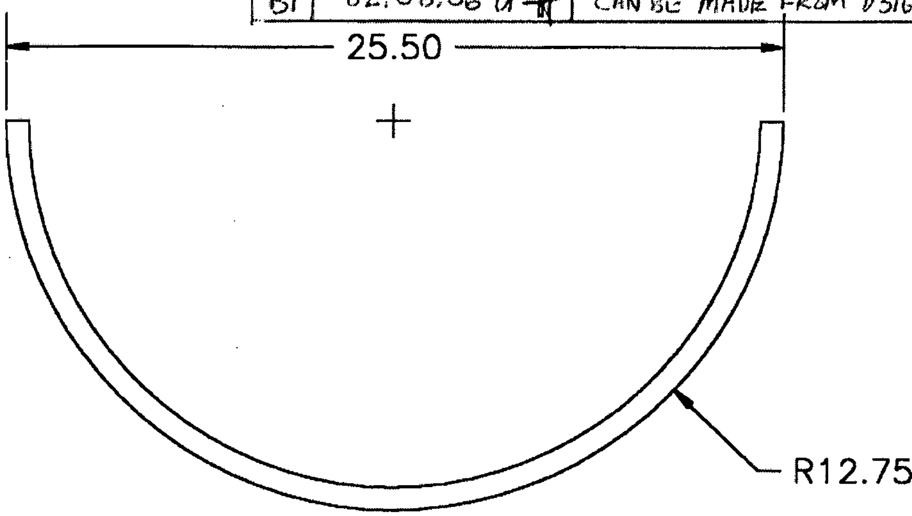



SECTION B-B SAME BOTH CENTER RIBS

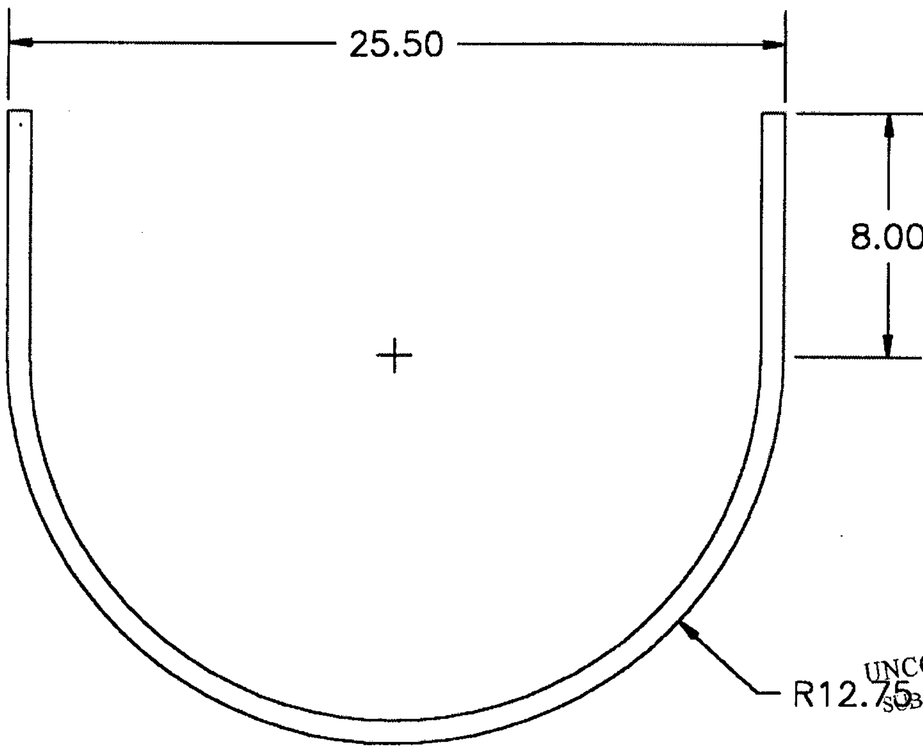
| DESIGN | DRAWN BY | DART AEROSPACE LTD<br>VICTORIA INTERNATIONAL AIRPORT, CANADA |
|---|---|---|
| B WILLIAMS | B WILLIAMS | |
| CHECKED | APPROVED | DRAWING NO. D2235 — REV. B — SHEET 1 OF 1 |
| DATE 94:12:16 | | TITLE BASKET RIBS — SCALE |
| B1 | 02.08.06 | CAN BE MADE FROM D3166-1 |

DART






D2235-1




D2235-3



CAN BE MADE FROM D3166-1 (B1)

MATERIAL: 304/316 SS, 3/4 X 3/4 X 0.063 WALL SQR.